

Dec 19.



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5955
Job Sheet 168496

Part No: D5955 Job Qty: 4 ea
Part Name: Saddle

Part Weight: 0 lbs Status: Scheduled Priority: Medium
Job Created: 11/15/17 Job Tracking No:
Due Date: 12/4/17 Created By: Mario Poulin
Type: Stock Description:
Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/1/17	0.00	0.00	Start Up Machining		FK 17-12-13
100	CNC Vertical Machining	4 pcs		12/2/17	0.32	11.11	HAAS 1		FK 17-12-13
110	QC	4 pcs		12/2/17	0.00	0.00	QC1		FK 17-12-13
120	QC	4 pcs		12/2/17	0.00	0.00	QC8		FK 17-12-13
130	HandFinish	4 pcs		12/2/17	0.00	0.35	HandFinish1		FK 17-12-13
140	Powdercoat	4 pcs		12/4/17	0.00	0.18	Powdercoat1		FK 17-12-13
150	QC	4 pcs		12/4/17	0.00	0.00	QC3		38
160	Packaging	4 pcs		12/4/17	0.00	0.00	Packaging3		50
170	QC21-SA	4 Ea		12/4/17	0.00	0.00	QC21		DEC 20 2017

Part Op 100 - 1-Machine as per folio D5955, Ensure Batch Number is entered
Descriptions: 110 - Inspect on CMM as per folio CMM018.
140 - START TIME: 8.30 O.V.T. 3.30 FINISH: 8.50.
M 138467.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-013	4	7	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐
Part No. _____		
NCR No. _____		
Date : _____		
Step #: _____	QTY Effective _____	

AGAINST DEPARTMENT/PROCESS

Cross tube ☐

Water Jet ☐

Engineering ☐

PART NO:
Revision:
Operation:
Change No:

Start up Operation

Saddle



DART
AEROSPACE
S020222

Description Work Order Deviation

Root Cause		FAI	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/I ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐	
Misidentified ☐	Past Due ☐		

Mfg Date: 12/12/17
Job No: 168496

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CANADA
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DART AEROSPACE LTD		Work Order:	168496
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.316	.316	.316	.316		
H	1.522	1.532		1.523	1.523	1.523	1.523		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.316	.316	.316	.316		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.491	.501	.501	.500		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.498	.499	.500		
T	1.625	1.645		1.625	1.625	1.625	1.625		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject				/	/	/	/	DAS	

Measured by:	FX
Date:	17-12-13

Audited by:	9-89
Date:	17/12/15

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
REV B	DATE 06.11.07	DESCRIPTION INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

